

Classifications									
EN14700									
T Z Fe1									
Characteristics and typical fields of application									
<div>•Rebuilding and hardfacing of Carbon steel parts.</div> <div>•Crawler tractor rollers and idlers, shafts, cylinders, mine car wheels, crane wheels...</div>									
Typical analysis of all-weld metal									
C	Si	Mn	Cr	Mo					
0.1	-	1.0	2.0	0.5					
Mechanical properties of all-weld metal – typical values (min. values)									
	PWHT		Shield gas		As Welded		Work-hardened		
	(°C/h)				(HB)		(HB)		
Typical					370≈HRC39				
Guarantee					360-410				
General Characteristics									
Microstructure		Machinability		Oxyacetylene cutting		Deposit thickness		Shield gas	
Bainite+ Martensite		Good		Possible		Depends upon application and procedure		-	
Operating Date									
Dia.(mm)		Current(A)		Voltage(V)		Stick-out(mm)			
2.8		300-400		26-30		35-40			